

Work Order ID 144400

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144400

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Item ID: D206-836-011 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 4/18/2016 Start Qty: 4.00 *4* Cust Item ID:

Required Date: 4/21/2016 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: SW Date: 20160413 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-2	A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D206-836-011 CH001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.12							
Quality Control									

4 ~~1~~ X ~~28~~ 9-89 MS 1604-21 APR 21 2016

4 ~~1~~ X ~~28~~ 9-89 APR 15 2016 DAS 27 9-89

4 X ~~28~~ 9-89 APR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																			
Root Cause		FAULT CATEGORY																																																									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																																																									
Misidentified ☐	Past Due ☐																																																										

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Item ID: D206-836-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD
 Start Date: 4/18/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/21/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00				4X	DAS 28 9-89		APR 21 2016
Packaging	Identify and pack for shipping as per PPP D206-836-011 Location : FG122								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							
Quality Control									

MC5 APR 22 2016

MC5 APR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 144400

144400

Parent Item: D206-836-011

D206-836-011

Parent Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 4/18/2016

Required Date: 4/21/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.05.28 NEW ISSUE DD VERF:JLM
REV:B 13.07.18 AS PER ECN13-561 DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-3		Manufactured	No				Each	27.0000		4		6 9-89	DAS 27 9-89
D4853-3													
Top Bracket (Replaces P/N G13013-5)													

DAS
28
9-89

Location

Loc Qty

Loc Code

ST519

27

109076

27

Each

28.0000

4

DAS
6
9-89

DAS
27
9-89

D4854-3

Manufactured

No

D4854-3

Lower Bracket (Replaces P/N G13013-6)

DAS
28
9-89

Location

Loc Qty

Loc Code

st526

28

104866

1

109081

27

Each

21.0000

4

DAS
6
9-89

DAS
27
9-89

D4855-1

Manufactured

No

D4855-1

Antenna Bracket (Replaces P/N G13013-3)

DAS
28
9-89

Location

Loc Qty

Loc Code

st526

21

143497

21

Each

31.0000

8

DAS
27
9-89

DAS
6
9-89

D2732-030

Manufactured

No

D2732-030

Rubber Cushion - 3"

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

135594

10

ST410

21

144013

21

8

APR 21 2016

Picklist Print

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Work Order ID: 144400

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Parent Item: D206-836-011

D206-836-011

Parent Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 4/18/2016

Required Date: 4/21/2016

Start Qty: 4.00

Required Qty: 4.00

AN4-16A

Purchased

No

Each

226.0000

8

DAS
6
9-89

AN4-16A

Bolt

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

125

M134606

125

ST343

96

M134509

96

Each

76.0000

8

DAS
6
9-89

DAS
27
9-89

AN4-11A

Purchased

No

AN4-11A

BOLT

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

20

120731

20

ST344

56

M128769

2

M133234

54

Each

62.0000

8

32

DAS
6
9-89

DAS
27
9-89

NAS1149D0432J

Purchased

No

NAS1149D0432J

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

40

m131026

40

ST264

22

m131026

22

APR 19 2016

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Shop Packet Print

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Picklist Print

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Work Order ID: 144400

144400

Parent Item: D206-836-011

D206-836-011

Parent Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 4/18/2016

Required Date: 4/21/2016

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

Each

2,400.000

4

16

MS21042L4

Locknut

**

DAS 27
9-89

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

339

m133769

339

OVER007

1500

m134509

500

m134606

1000

ST303

427

m134055

9

m134502

418

ST305

97

m130922

97

DAS 28
9-89

APR 19 2016

16

REF ID: A6017

DAS
28
9-89

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
1				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT